

Process Sheet

Dupl. ca

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40608 *1A*
Estimate Number : 13433
P.O. Number :
This Issue : 24/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 17/07/2008 Type : LARGE FAB ASSY
Previous Run :
Written By :
Checked & Approved By : *MF 08-07-24*
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY
Part Number : PB674300115
Drawing Number : B6743001 P.7
Project Number : N/A
Drawing Revision : B1
Material :
Due Date : 24/07/2008
Qty: 15
Um: EA

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PB6743001257 Inner Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube
batch: *4C585*

12 08-07-24

2.0 PB6743001249 Inner Tube Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inner Tube Bushing
batch: *M12141*

12 08-07-24

3.0 PB6743001253 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset
batch: *340045*

12 08-07-24

4.0 PB6743001254 Gusset



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Gusset
batch: *340053*

12 08-07-24

5.0 PB674300171 PB67-43001-71



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-71
batch: *340027*

12 08-07-24

ay, 24/07/2008 8:23:49 AM
Anle Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg



11/28/07-24

7.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



10/08/07-25

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



S 08/07-26

9.0 MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
HELICAL INSERT



M 17935

10/08/07-26

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helical
- 3- install helical insert as per dwg



11/08/07-27

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



S 08/07-28

12.0 HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



13.0 POWDER COATING

POWDER COATING



M 102316



5X

Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M-F 08/07/31

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

(3A)

START TIME:

1:40

OVEN TEMPERATURE:

320

FINISH TIME:

2:10

m/h

08/07/31

14.0

QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

08/07/31

6

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PB674300173



20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

20 Degree Cover Plate

batch: 40094

H 08-08-26

16.0

PB674300183



PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-83

batch: 40096

H 08-08-26

17.0

MS27039110



Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Screw

batch: 108986

H 08-08-26

18.0

NAS1149F0316P



WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

WASHER

batch: 108473

H 08-08-26

19.0

SMALL FAB.1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

H 08-08-26

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S08/09/12

21.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S09

8/9/12 ax SP

22.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/09/15 SP

Job Completion



JMF 08-09-12

